

# Work Order ID 84048

\*84048\*

Page 1

May-01-12 2:33:13 PM

Item ID: D4034-041 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Aft Upper Rib Assembly  
 Start Date: 01/05/2012 Start Qty: 3.00 \*3\*  
 Required Date: 07/05/2012 Req'd Qty: 3.00 \*3\*  
 Reference: Cust Item ID:  
 Customer:

Approvals: Process Plan: MLJ Date: 12/05/01 Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4034	B

100 Weld per dwg A/R S.S. rod Batch: M127130 0.00  
 \*100\*  
 Large Fab Memo 0.00  
 Large Fab 1 Assemble ribs to hoop and weld as per dwg DT9564  
 2 Weld bushing in rib and grind weld flush as per dwg

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00  
 \*110\*  
 QC Memo 0.00  
 Quality Control

120 QC5- Inspect part completeness to step on W/O 0.00  
 \*120\*  
 QC Memo 0.00  
 Quality Control

2 12/CC 12-8-8

2x 12.8.9 DAS 24

2x 12.8.9 DAS 24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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 Required Date: 07/05/2012 Req'd Qty: 3.00 \*3\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>WA</u>	0.00							
*130*									
Packaging	Memo	0.00				2	12.8.9		DAS 24 3.8
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
*140*									
QC	Memo	0.00							
Quality Control									

12/8/9 JH  
 MF  
 12-08-08

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

May-01-12 2:33:17 PM

Page 1

Work Order ID: 84048

**\*84048\***

Parent Item: D4034-041

**\*D4034-041\***

Parent Item Name: Aft Upper Rib Assembly

Start Date: 01/05/2012

Required Date: 07/05/2012

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC IPP Rev:B as  
per dwg revA 10.03.15 verified by:EC IPP Rev:C 11.01.19 AS PER  
DWG REV.B DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4034-1		Manufactured	No			100	Each	26.0000	1	3			
<b>*D4034-1*</b>													
Rib													

\*\* CC 12-8-8

## Location

## Loc Qty

## Loc Code

WA

-6 ~~B85~~

81145

12

81467

6

82260

6

WA006

32

82259

2

B83755 → (2x)

D4034-3		Manufactured	No			100	Each	6.0000	1	3			
<b>*D4034-3*</b>													
Rib													

\*\* CC 12-8-8

## Location

## Loc Qty

## Loc Code

WA

6

58408

0

82982

6

B85636 → (2x)

D4021-7		Manufactured	No			100	Each	16.0000	1	3			
<b>*D4021-7*</b>													
Hoop													

\*\* B85015 → 1x B87909 → 2x 12-08-08

## Location

## Loc Qty

## Loc Code

WA005

16

82704

6

82976

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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May-01-12 2:33:17 PM

Page 2

Work Order ID: 84048

\*84048\*

Parent Item: D4034-041

\*D4034-041\*

Parent Item Name: Aft Upper Rib Assembly

Start Date: 01/05/2012

Required Date: 07/05/2012

Start Qty: 3.00

Required Qty: 3.00

D4021-9

Manufactured No

100

Each

73.0000

4

12

\*D4021-9\*

\*\*

CC 17-8-8

Bushing

Location

Loc Qty

Loc Code

WA

63 884 717

66437

0

72482

0

82348

63

WA005

10

66437

2

70333

4

72482

4

8x

May-01-12 2:33:17 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

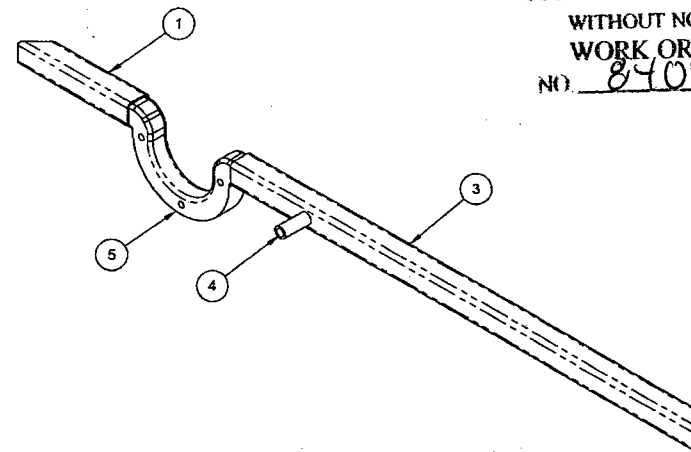
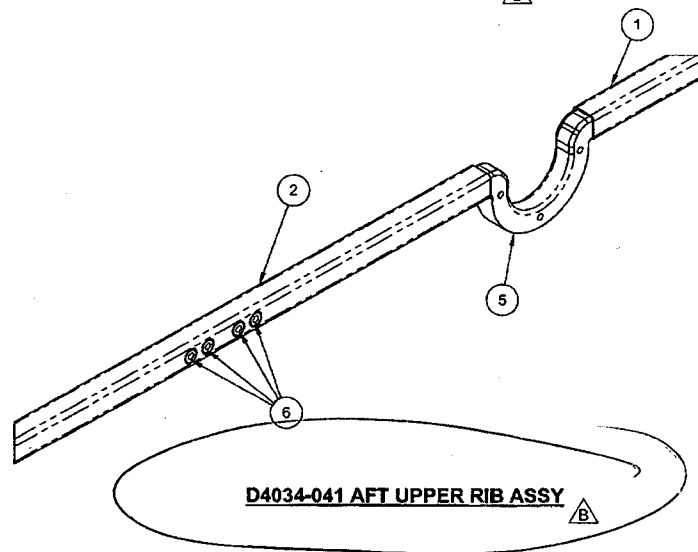
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**NOTE:** Date & initial all entries



ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4034-041	AFT UPPER RIB ASSY
		X	D4034-043	FWD UPPER RIB ASSY
1	1	1	D4034-1	RIB
2	1		D4034-3	RIB
3		1	D4034-5	RIB
4		1	D2327-3	SPACER BUSHING
5	1	1	D4021-7	HOOP
6	4		D4021-9	BUSHING



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 84048 MJS  
12/05/01

RELEASED  
R 2011-01-18  
MB

B	ADDITIONAL HOLES ADDED ON D4034-3 RIB	SC	10.12.20
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	B	DRAWING NO.	REV. B
MFG. APPR.	MJS	D4034	SHEET 1 OF 4
APPROVED	MJS	TITLE	SCALE
DE APPR.	MJS	UPPER RIB ASSY, BASKET BASE	NTS
DATE	10.12.20	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD  THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT  WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

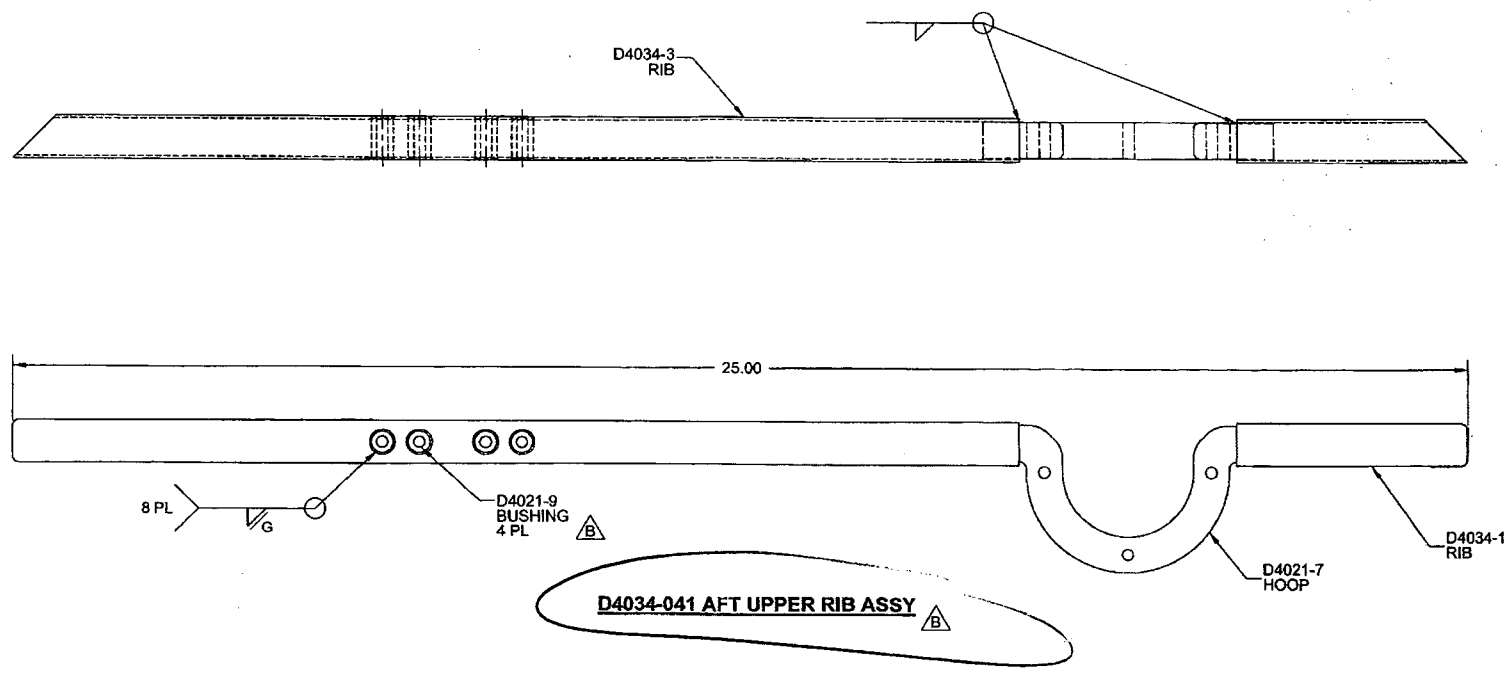
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

84048



RELEASED  
2011-01-18

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 1.61 lbs
  - 8) WELD PER DART QSI 004

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	JS	DRAWING NO.	REV. B
MFG. APPR.	JS	<b>D4034</b>	SHEET 2 OF 4
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	<b>UPPER RIB ASSY, BASKET BASE</b>	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

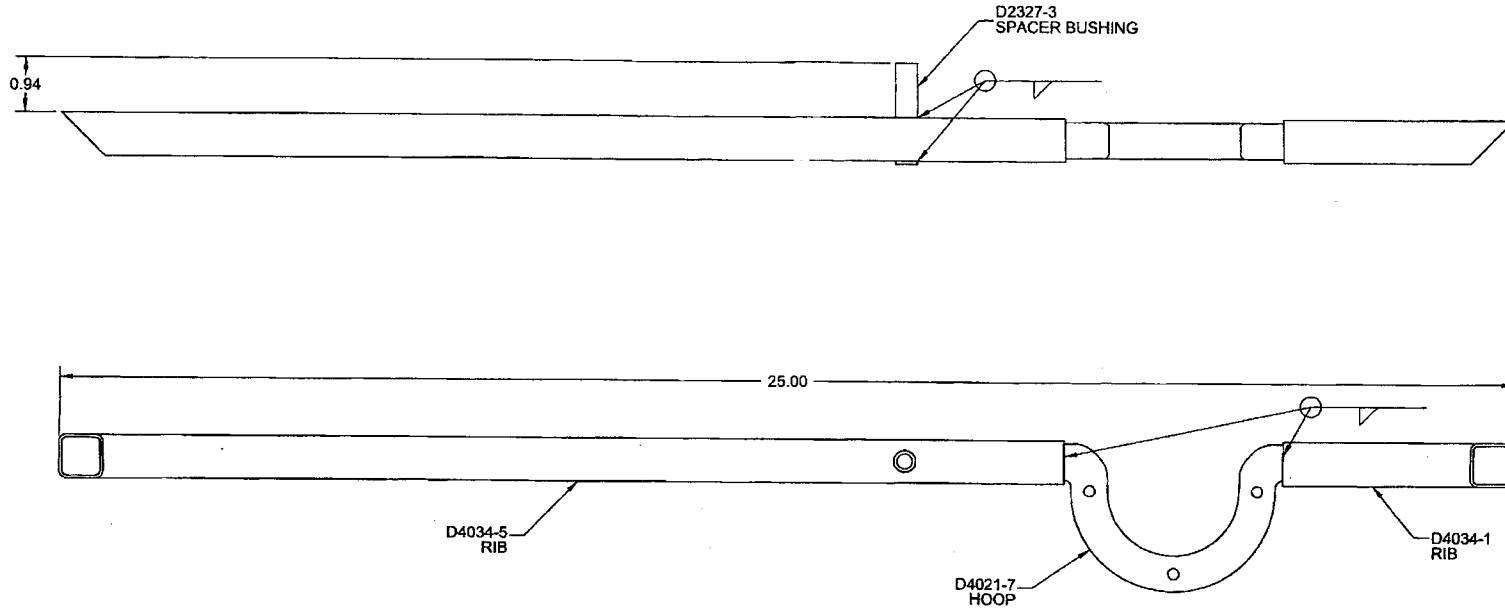
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

040.48



**D4034-043 FWD UPPER RIB ASSY**

**RELEASED**  
2011-01-18  
JWP

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 1.58 lbs
  - 8) WELD PER DART QSI 004

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	JS	DRAWING NO.	REV. B
MFG. APPR.	[Signature]	D4034	SHEET 3 OF 4
APPROVED	[Signature]	TITLE	SCALE
DE APPR.		UPPER RIB ASSY, BASKET BASE	NTS
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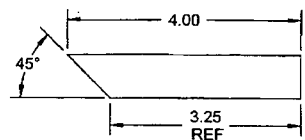
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

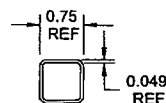
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

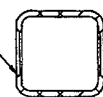
**NOTE:** Date & initial all entries



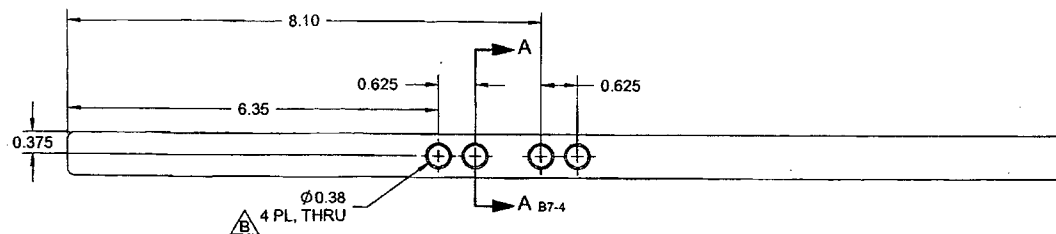
**D4034-1 RIB**



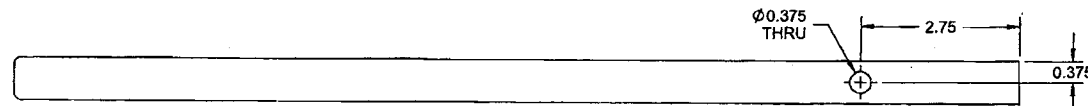
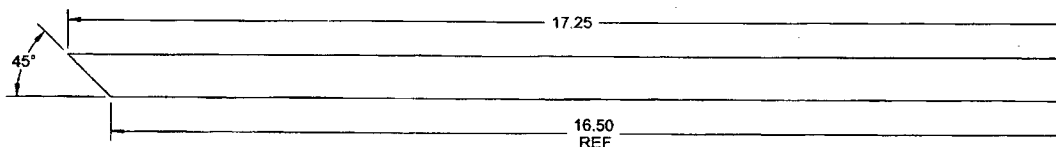
BREAK EDGE  
0.030 X 45°  
TYP



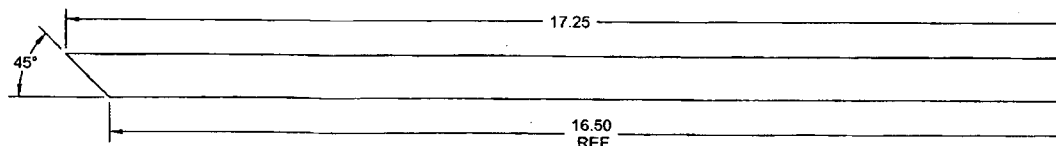
**SECTION A-A D44**



**D4034-3 RIB**



**D4034-5 RIB**



84048

**RELEASED**  
2011-01-10

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.13 lbs  
-3 & -5: 0.62 lbs

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO. <b>D4034</b>	REV. B
MFG. APPR.		SHEET 4 OF 4	
APPROVED		TITLE	SCALE
DE APPR.		<b>UPPER RIB ASSY, BASKET BASE</b>	NTS
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